

Work Order ID 147226

Friday, June 10, 2016 10:20:39 AM

147226

Page 1

Item ID: D407-797-014 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID:
 Item Name: Quick Release Heli-Utility-Basket™ RH 407 Lightweight Lid Stop ***NS2***
 Start Date: 6/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: DISSASSEMBLE

Approvals: Process Plan: MF Date: 16-6-10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-797-1	B								

150 0.00

150

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D407-797-014 X 1 B131540

DISSASSEMBLE AND RETURN TO STOCK UNDER ORIGINAL BATCH
NUMBER:

D407-797-111 X 1 B84306

D4272-014 X 1 B75292

MF 16-6-10

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

16/06/15 MF / 16-6-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

Friday, June 10, 2016 10:20:38 AM

Page 1

Work Order ID: 147226

147226

Parent Item: D407-797-014

D407-797-014

Parent Item Name: Quick Release Heli-Utility-Basket™ RH 407 Lightweight Lid

Start Date: 6/8/2016

Required Date: 6/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.29 new issue DD verf:JLM IPP Rev:B
11.02.10 as per IIN rev.A DD verf:JLM IPP Rev:C 11.09.12
@ chg 002 DD verf:EC IPP REV:D 12.03.06 AS PER
ECN12-535 DD VERF:EC IPP REV:E 12.07.24 AS PER ECN12-611
DD VERF:EC IPP Rev:F 13.07.08 as per CHG005 (ECN13-582) DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D407-797-014		Manufactured	No				Each	1.0000		1			

D407-797-014

Quick Release Heli-Utility-Basket™ RH 407 Lightweight Lid

**

Location

Loc Qty

Loc Code

BSKT003

1

131541

1

131540 MF 16-6-10

D407-797-111

Manufactured No

Each

1.0000

-1

D407-797-111

Quick Release Mounting 407 Fits LH or RH

**

Location

Loc Qty

Loc Code

FG034

1

84306

1

MF 16-6-10

D4272-014

Manufactured No

Each

1.0000

-1

D4272-014

Basket Assembly, Light Weight Lid, RH

**

Location

Loc Qty

Loc Code

FG

1

75292

1

MF 16-6-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

LOT TRACKING !!

Reason	Parent Item ID	Lot Qty	Lot Nbr	Avg Cost Amt	Last Cost Amt
75291	D4272-014	-1	75292	\$7,428.63	\$7,428.63
75291	D407-797-111	-1	84306	\$2,325.99	\$2,352.03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause				FAULT CATEGORY			
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Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
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Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

LOT TRACKING !!

Reason	Parent Item ID	Lot Qty	Lot Nbr	Avg Cost Amt	Last Cost Amt
131540	D407-797-014	-1	75291	\$8,090.72	\$8,090.89
131540	D4307-265	-1	131264	\$9.47	\$9.47
131540	97447A010	-4	m131311	\$.03	\$.03

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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